










Date: Thursday, 10/08/2006 9:56:07 AM
User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: DOOR WEDGE
Job Number	: 28107		
Estimate Number	: 12111		
P.O. Number	: N/A	Part Number	: D32003
This Issue	: 10/08/2006 S.O. No. : N/A	Drawing Number	: D3200 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : MACHINED PARTS	Drawing Revision	: A
Previous Run	: 25634	Material	: N/A
Written By	:	Due Date	: 30/08/2006 Qty: 50 Um: Each
Checked & Approved By	:		
Comment	: Est Rev:A Removed from 9 Digit 06-01-25 JLM		
Additional Product			
Job Number: 			
Seq. #:	Machine Or Operation:	Description :	
1.0	MUHMWB10	UHMW 1" Black	
			
<p>Comment: Qty.: 0.0158 sf(s)/Unit Total : 0.7875 sf(s)</p> <p>UHMW 1" Black</p> <p>Material: Black UHMW 0.95" or 1.00" thick</p> <p>Use bearpaw scrap material (MUHMWB10)</p> <p>Identify for D3200-1</p> <p>Batch: 101254 11 101254 7/2 06/08/30 50</p>			
2.0	BAND SAW	BAND SAW	
			
<p>Comment: BAND SAW</p> <p>Cut blank: 2.700" x 2.700 1.00" x 1.80" 7/2 06/08/30 50</p>			
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
			
<p>Comment: HAAS CNC VERTICAL MACHINING #1</p> <p>1-Machine D3200-3 as per Folio FA337 and Dwg D3200</p> <p>2-Deburr J.F. 7/2 06/08/30 51</p>			
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
			
<p>Comment: INSPECT PARTS AS THEY COME OFF MACHINE J.F. 7/2 06/08/30 51</p>			

09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: DP Date: 06/07/06
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

J.G 06/08/31 51

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 57414

24/4 31 (51)
LB 06/08/31 (51)

7.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/09/06

Job Completion



U 0609-01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

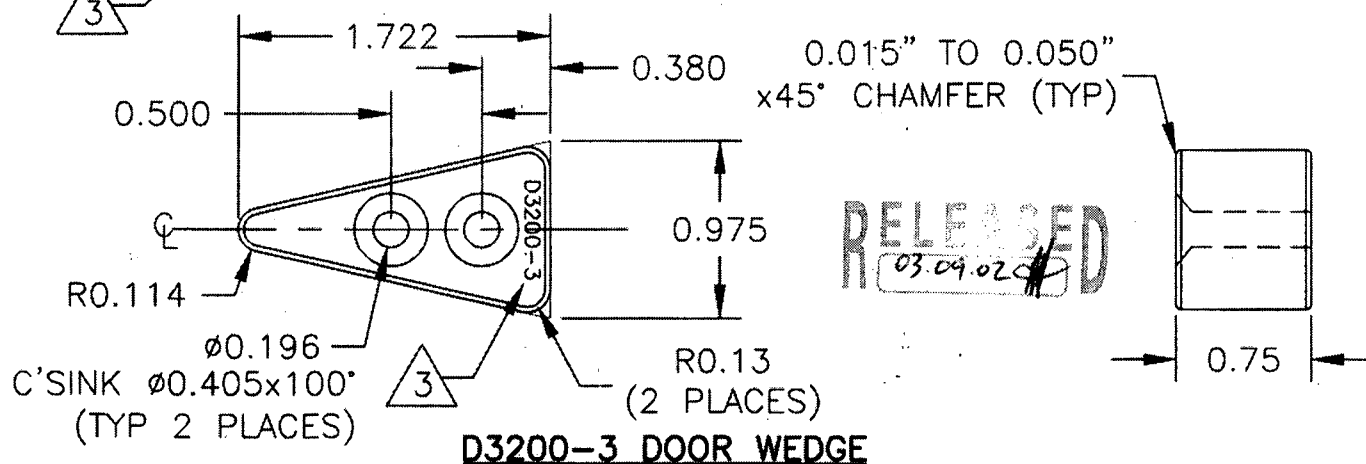
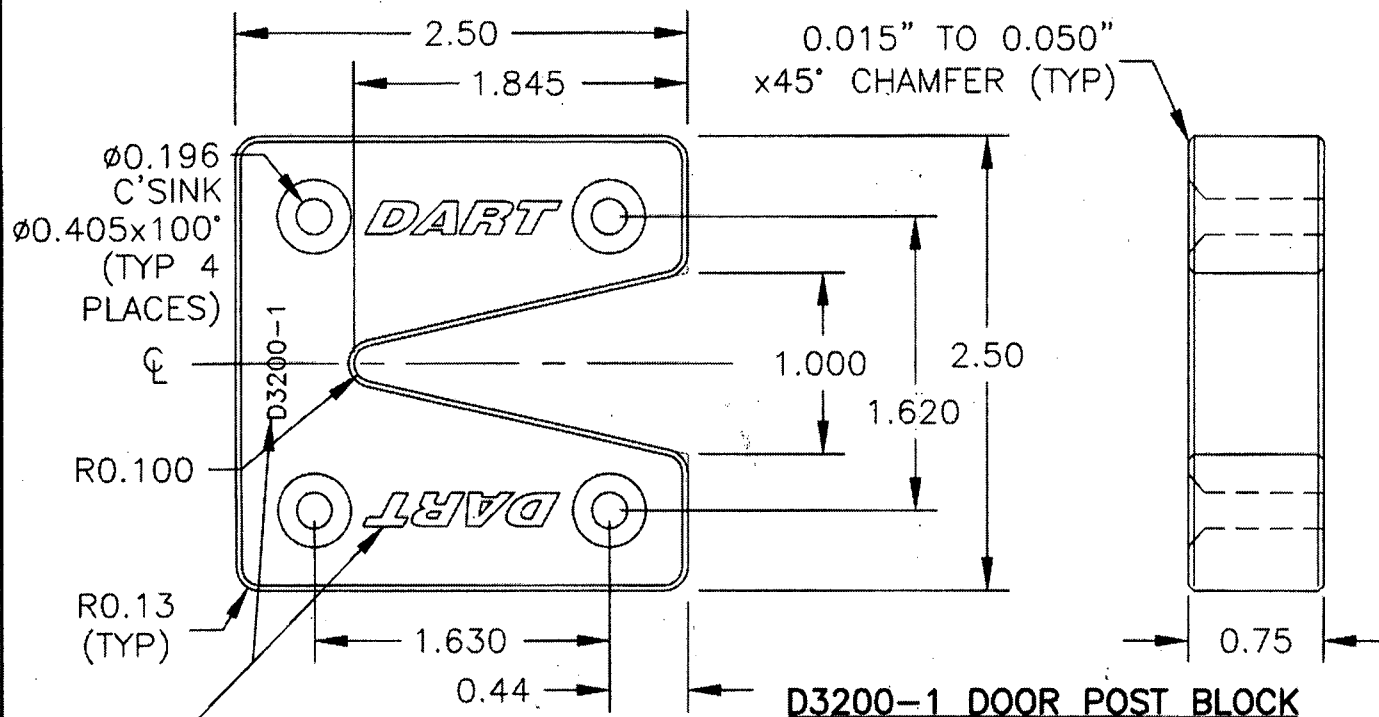
QA: N/C Closed: _____ Date: _____

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DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D3200	REV. A SHEET 1 OF 1
DATE 03.08.06		TITLE DOOR WEDGE	SCALE 1:1
A	03.08.06	NEW ISSUE	



D3200-1/-3

- 1) MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689
- 2) PARTS ARE SYMMETRIC ABOUT CENTERLINE
- 3) ENGRAVE DART LOGO AND P/N IN AREAS SHOWN
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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